

GENERAL

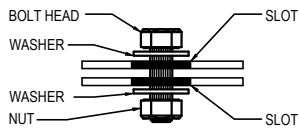
A00010 - WASHER REQUIREMENTS ERECTOR NOTE

A00020 - FIELD WELD REQUIREMENTS

A00030 - STANDARD ANGLE SCHEDULE

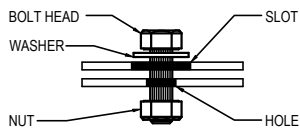
A00010 - WASHER REQUIREMENTS ERECTOR NOTE

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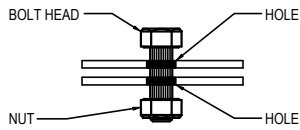
SLOT TO SLOT CONNECTIONS

WASHERS REQUIRED ON BOTH SIDES OF MATERIAL IF SLOTS ARE ON BOTH SIDES. (EXCEPTION: SEE DETAIL AT RIGHT FOR LAPPED ZEE MEMBERS)



SLOT TO HOLE CONNECTIONS

ONE WASHER REQUIRED ON SLOTTED SIDE ONLY.



HOLE TO HOLE CONNECTIONS

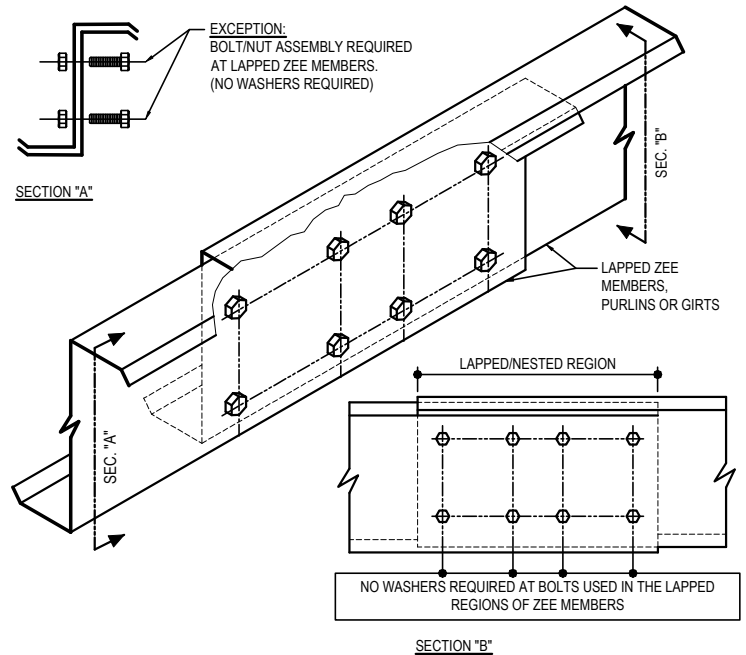
NO WASHERS REQUIRED WHEN SLOTS ARE NOT USED.

WASHER PART NUMBERS

H0200 - 1/2" FLAT WASHER	H0240 - 1" FLAT WASHER
H0210 - 5/8" FLAT WASHER	H0250 - 1 1/8" FLAT WASHER
H0220 - 3/4" FLAT WASHER	H0260 - 1 1/4" FLAT WASHER
H0230 - 7/8" FLAT WASHER	

WASHER REQUIREMENTS ERECTOR NOTE

(UNLESS NOTED OTHERWISE ON DRAWINGS)



A00010

Detailer Notes:

- 1) N/A

A00020 - FIELD WELD REQUIREMENTS

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FIELD WELD REQUIREMENTS ERECTOR NOTE

(UNLESS NOTED OTHERWISE ON DRAWINGS)

ALL FIELD WELDING MUST BE PERFORMED BY AWS/CWB CERTIFIED WELDERS WHO ARE QUALIFIED FOR THE WELDING PROCESSES AND POSITIONS INDICATED. ALL WORK MUST BE COMPLETED AND INSPECTED IN ACCORDANCE WITH THE APPLICABLE AWS/CWB SPECIFICATIONS. WELD ELECTRODES USED FOR THE SMAW (OR STICK) WELD PROCESS MUST BE 70 KSI/483 MPa MATERIAL AND LOW HYDROGEN CONTENT.

FIELD WELDING GALVANIZED STEEL RECOMMENDATIONS

PREPARATION OF WELD AREA

AWS D-19.0, WELDING ZINC COATED STEEL, CALLS FOR WELDS TO BE MADE ON STEEL THAT IS FREE OF ZINC IN THE AREA TO BE WELDED. FOR GALVANIZED STRUCTURAL COMPONENTS, THE ZINC COATING SHOULD BE REMOVED AT LEAST ONE TO FOUR INCHES (2.5-10 CM) FROM EITHER SIDE OF THE INTENDED WELD ZONE AND ON BOTH SIDES OF THE WORKPIECE. GRINDING BACK THE ZINC COATING IS THE PREFERRED AND MOST COMMON METHOD; BURNING THE ZINC AWAY OR PUSHING BACK THE MOLTEN ZINC FROM THE WELD AREA ALSO ARE EFFECTIVE.

TOUCH-UP OF WELD AREA

WELDING ON GALVANIZED SURFACES DESTROYS THE ZINC COATING ON AND AROUND THE WELD AREA. RESTORATION OF THE AREA WILL BE PERFORMED IN ACCORDANCE WITH ASTM A 780, STANDARD PRACTICE FOR REPAIR OF DAMAGED AND UNCOATED AREAS OF HOT-DIP GALVANIZED COATINGS, WHICH SPECIFIES THE USE OF PAINTS CONTAINING ZINC DUST, ZINC-BASED SOLDERS OR SPRAYED ZINC. ALL TOUCHUP AND REPAIR METHODS ARE CAPABLE OF BUILDING A PROTECTIVE LAYER TO THE THICKNESS REQUIRED BY ASTM A 780.

SAFETY & HEALTH

WHEN WELDING DIRECTLY ON GALVANIZED STEEL IS UNAVOIDABLE, OSHA PERMISSIBLE EXPOSURE LIMITS (PELS) MAY BE EXCEEDED AND EVERY PRECAUTION, INCLUDING HIGH-VELOCITY CIRCULATING FANS WITH FILTERS, AIR RESPIRATORS AND FUME-EXTRACTION SYSTEMS SUGGESTED BY AWS, SHOULD BE EMPLOYED.

FUMES FROM WELDING GALVANIZED STEEL CAN CONTAIN ZINC, IRON AND LEAD. FUME COMPOSITION TYPICALLY DEPENDS ON THE COMPOSITION OF MATERIALS USED, AS WELL AS THE HEAT APPLIED BY THE PARTICULAR WELDING PROCESS. IN ANY EVENT, GOOD VENTILATION MINIMIZES THE AMOUNT OF EXPOSURE TO FUMES.

PRIOR TO WELDING ON ANY METAL, CONSULT ANSI/ASC Z-49.1, SAFETY IN WELDING, CUTTING AND ALLIED PROCESSES, WHICH CONTAINS INFORMATION ON THE PROTECTION OF PERSONNEL AND THE GENERAL AREA, VENTILATION AND FIRE PREVENTION.

A00020

INFORMATION COURTESY OF AMERICAN GALVANIZERS ASSOCIATION

Detailer Notes:

1) N/A

A00030 - STANDARD ANGLE SCHEDULE

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STANDARD ANGLE SCHEDULE

<p><u>MAE0</u></p>	<p>EAVE ANGLE GALVANIZED 4" x 5" x 120"</p>	<p><u>MAL02</u></p>	<p>LINER EAVE ANGLE 2:12 GALVANIZED 3" x 3" x 120"</p>
<p><u>MAF0</u></p>	<p>SCULPTURED EAVE ANGLE GALVANIZED 5" x 8" x 120"</p>	<p><u>MAL05</u></p>	<p>LINER EAVE ANGLE 4:12 GALVANIZED 3" x 3" x 120"</p>
<p><u>MAG01</u></p>	<p>GIRT ANGLE GALVANIZED 1" x 2-1/2" x 12"</p>	<p><u>MAL07</u></p>	<p>LINER EAVE ANGLE 1:12 GALVANIZED 3" x 3" x 120"</p>
<p><u>MAG02</u></p>	<p>GIRT ANGLE GALVANIZED 1" x 2-1/2" x 24"</p>	<p><u>MAL12</u></p>	<p>LINER EAVE ANGLE 2:12 GALVANIZED 3" x 7-3/4" x 120"</p>
<p><u>MAG03</u></p>	<p>GIRT ANGLE GALVANIZED 1" x 2-1/2" x 30"</p>	<p><u>MAP01</u></p>	<p>RAKE PARAPET ANGLE GALVANIZED 2" x 12" x 120"</p>
<p><u>MAG10</u></p>	<p>GIRT ANGLE GALVANIZED 1" x 2-1/2" x 120"</p>	<p><u>MAP02</u></p>	<p>RAKE PARAPET ANGLE GALVANIZED 6" x 6" x 120"</p>
<p><u>MAH0</u></p>	<p>EAVE STRUT ANGLE GALVANIZED 1" x 2-1/2" x 12"</p>	<p><u>MAR01</u></p>	<p>RAKE ANGLE GALVANIZED 3" x 5" x 242"</p>
<p><u>MAL01</u></p>	<p>LINER LOW EAVE ANGLE GALVANIZED 6" x 7-3/4" x 120"</p>	<p><u>MAR02</u></p>	<p>STANDING SEAM RAKE/ BASE ANGLE GALVANIZED 2" x 3" x 242"</p>

A00030

Detailer Notes:

- 1) N/A